

Work Order ID 76398

76398

Page 1

November-11-11 12:48:15 PM

Item ID: D412-742-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Float Skidtube

Stop ***NS2***

Start Date: 11/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 11/11/11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3391

HUR Rev. I CP 11.11.15

0.00

100

100

DOCUMENT CONTROL

0.00

DC

Memo



Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CH0004

CH6 005

Handwritten signature For MLJ 11-12-7
(1)

B76398

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.11.15		ASSEMBLE PER D3391 Rev.I Tube 15 CHG 005				 11.11.15 Q51642	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O: 176398		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.12.09	100	Acceptable to assemble skid tube with D4095-xxx WEARPLATES PER D3391 Rev. I, which are equivalent to D3564-xxx WEARPLATES, HOWEVER THEY HAVE NO GASKETS KDSI 9517 Rev. B	OP 11.12.09	11.12.09		11.12.09	

Part No: D412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item Name: Replacement Float Skidtube

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Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

HandFinishing

0.00

HandFinish

Hand Finishing

Memo

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/RSikaflex-241/-291 11/11/19 443
Expiry date: 12/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 11/11/19 443
Expiry date: 12/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/RLPS Procyon 11/11/19 596

1 0 11/12/07

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Revision ID:

Item Name: Replacement Float Skidtube

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Start Date: 11/11/2011 Start Qty: 1.00

1

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Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-043								
	Location: <u>73</u>								
	PPP Rev: <u>5/11 IP</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF
11-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

November-11-11 12:48:21 PM

Page 1

Work Order ID: 76398

76398

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
IPP Rev:C 07-05-28 As per Rev F JLM
IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F
11.11.01 as per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			110	Each	2,163.000	24	24			
AN3C4A									**				
BOLT													

Location

Loc Qty

Loc Code

ST350

2163

117313

2

117688

5

117872

22

118112

16

118451

2

118706

142

118838

974

119328

1000

224

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

November-11-11 12:48:21 PM

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 110 Each 260.0000 10 ****** 10/8
AN3C6A HU 11/12/06 X PTO
 BOLT

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST350	100	
119449	100	
ST351	159	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	104	

AN3C7A Purchased No 110 Each 115.0000 4 ****** 4
AN3C7A HU 11/12/06
 BOLT

Location	Loc Qty	Loc Code
ST351	115	
113149	14	
116169	1	
117313	10	
117619	12	
117688	18	
118422	60	

AN960C10L NAS1149C0332 Purchased No 110 Each 0.0000 38 ****** 38
 R
***AN960C10I *** 11197361 x 381 HU 11/12/06
 washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/12/08	110	Replace (x2) AN3CGA bolts with (x2) AN3C-3A M11B45	JP	11/02/08	x2	CP 11.12.06 CS/042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 3

November-11-11 12:48:21 PM

Work Order ID: 76398

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3391-021 Manufactured No

110 Each 0.0000 1 1

D3391-021

****** B75937 (x1) MU 11/12/06

Fwd Tube Assembly

D3391-023 Manufactured No

110 Each 0.0000 1 1

D3391-023

****** B76390 (x1) MU 11/12/06

Mid Tube Assembly

D3391-025 Manufactured No

110 Each 2.0000 1 1

D3391-025

****** B76395 (x1) MU 11/12/06

Aft Tube Assembly

Location

Loc Qty

Loc Code

FP

2

73013

1

73014

1

~~D3564-5~~ *D4095-645* Manufactured No

110 Each 22.0000 1 1

~~***D3564-5***~~

****** B76536 (x1) MU 11/12/06

Wearshoe

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

12

74543

12

FP19

8

73330

8

~~D3566-5~~ *N/A* Manufactured No

110 Each 30.0000 1 1

~~***D3566-5***~~

Gasket

Location

Loc Qty

Loc Code

FP002

30

74387

8

75069

22

November-11-11 12:48:21 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 4

November-11-11 12:48:21 PM

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76398

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4095-041 Manufactured No

110

Each

0.0000

1

1

D4095-041

Wearplate Assembly

B76047 (u) ul u112105

D4095-043 Manufactured No

110

Each

0.0000

1

1

D4095-043

Wearplate Assembly

B76048 (u) ul u112106

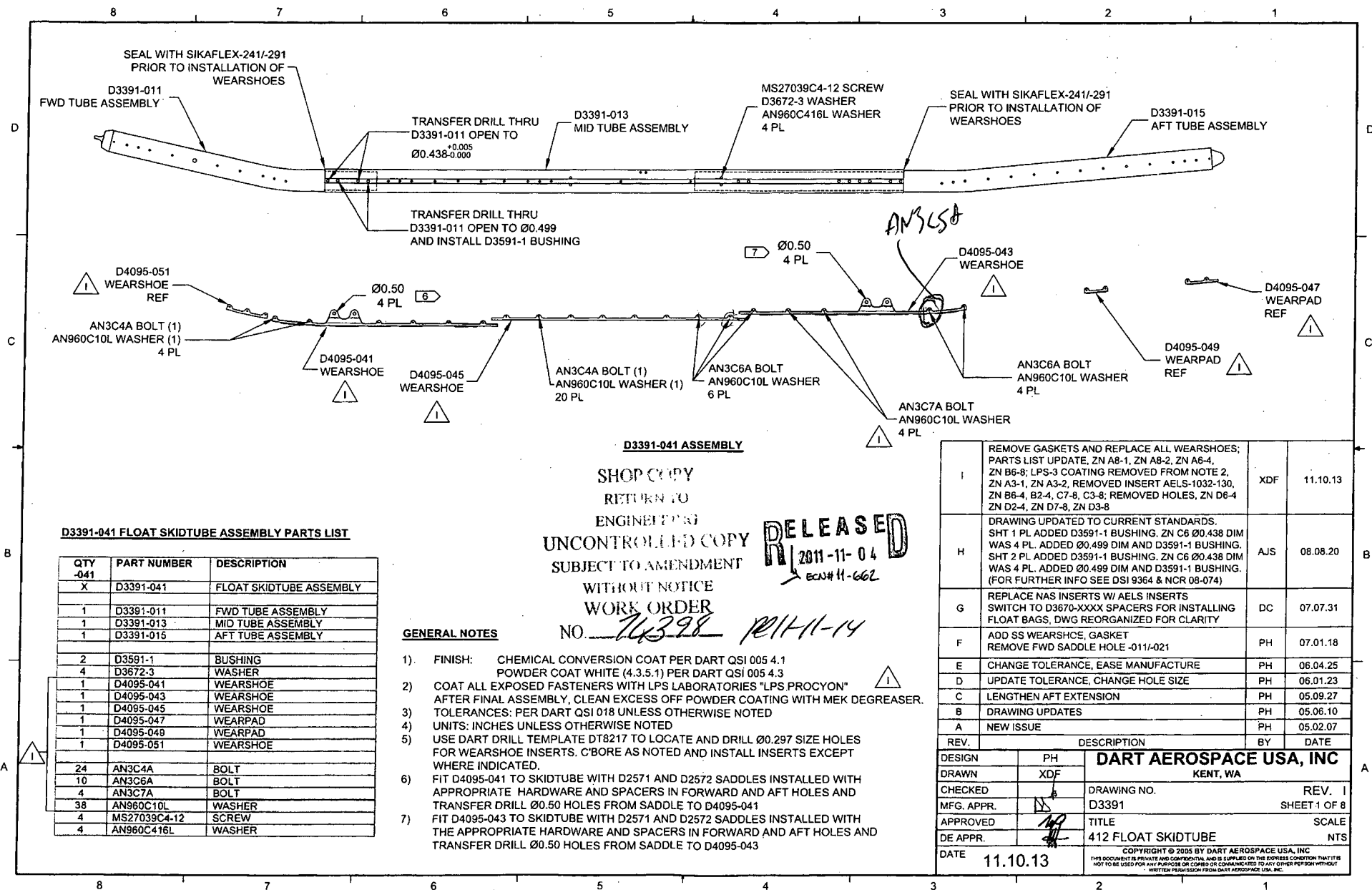
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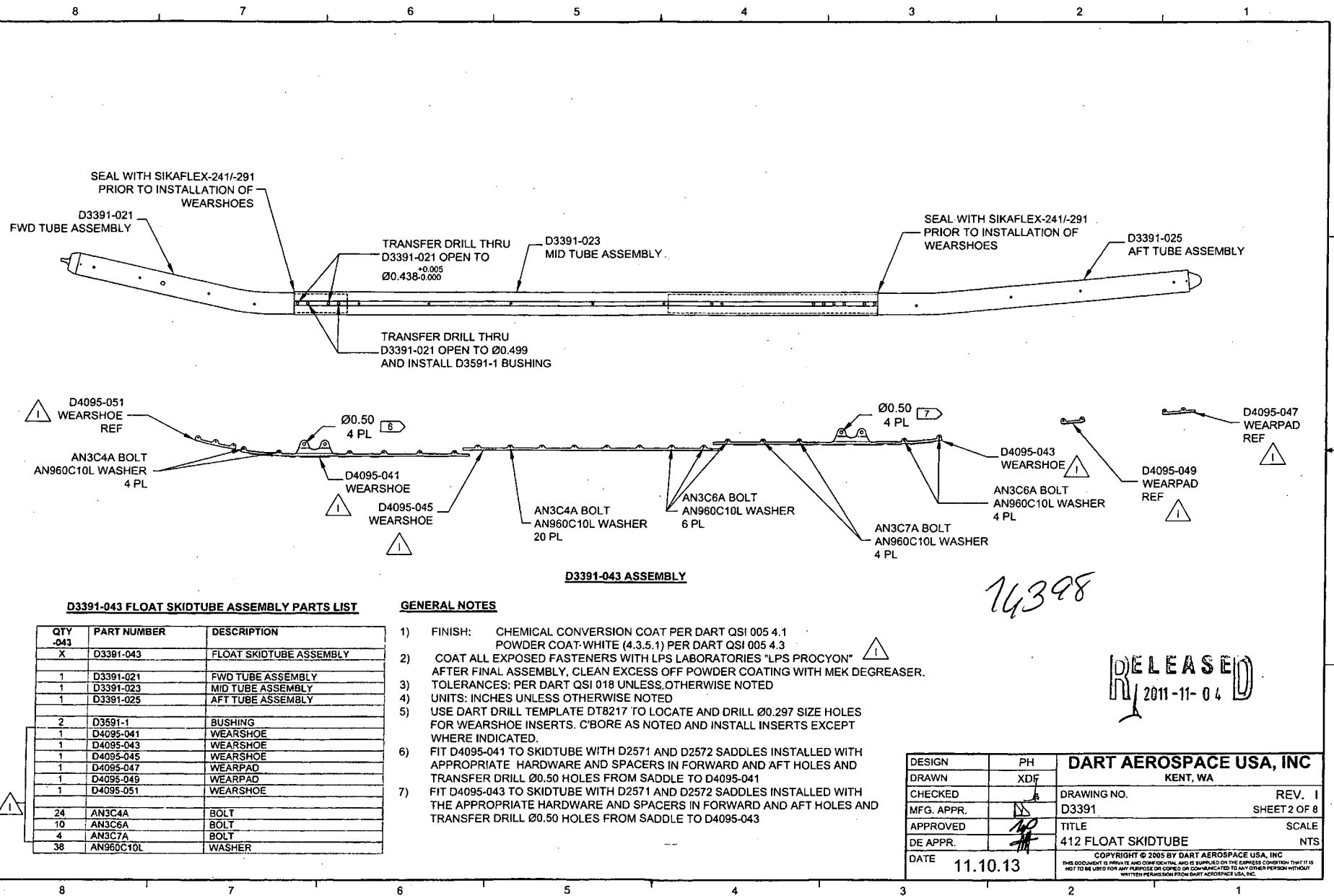
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT-WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	J	DRAWING NO.	REV. 1
MFG. APPR.	J	D3391	SHEET 2 OF 8
APPROVED	J	TITLE	SCALE
DE APPR.	J	412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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2011-11-04

14398

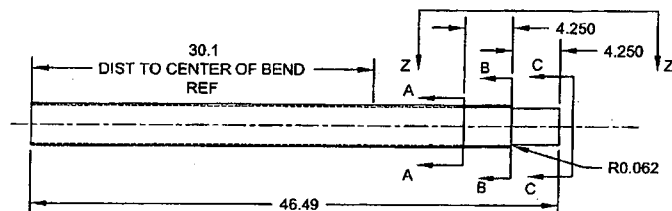
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

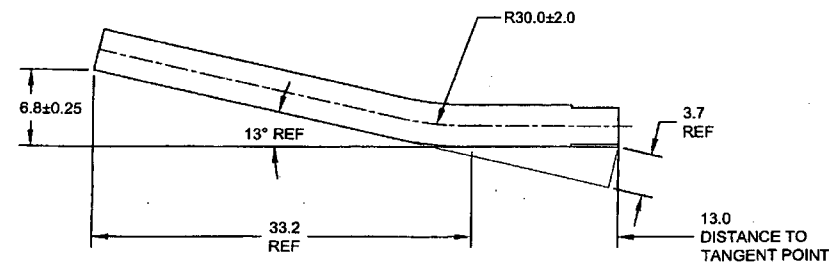
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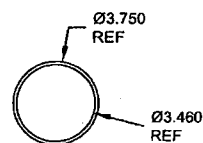
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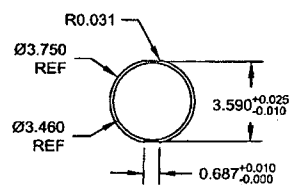
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



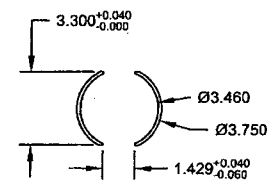
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



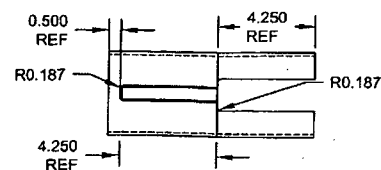
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

76398

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

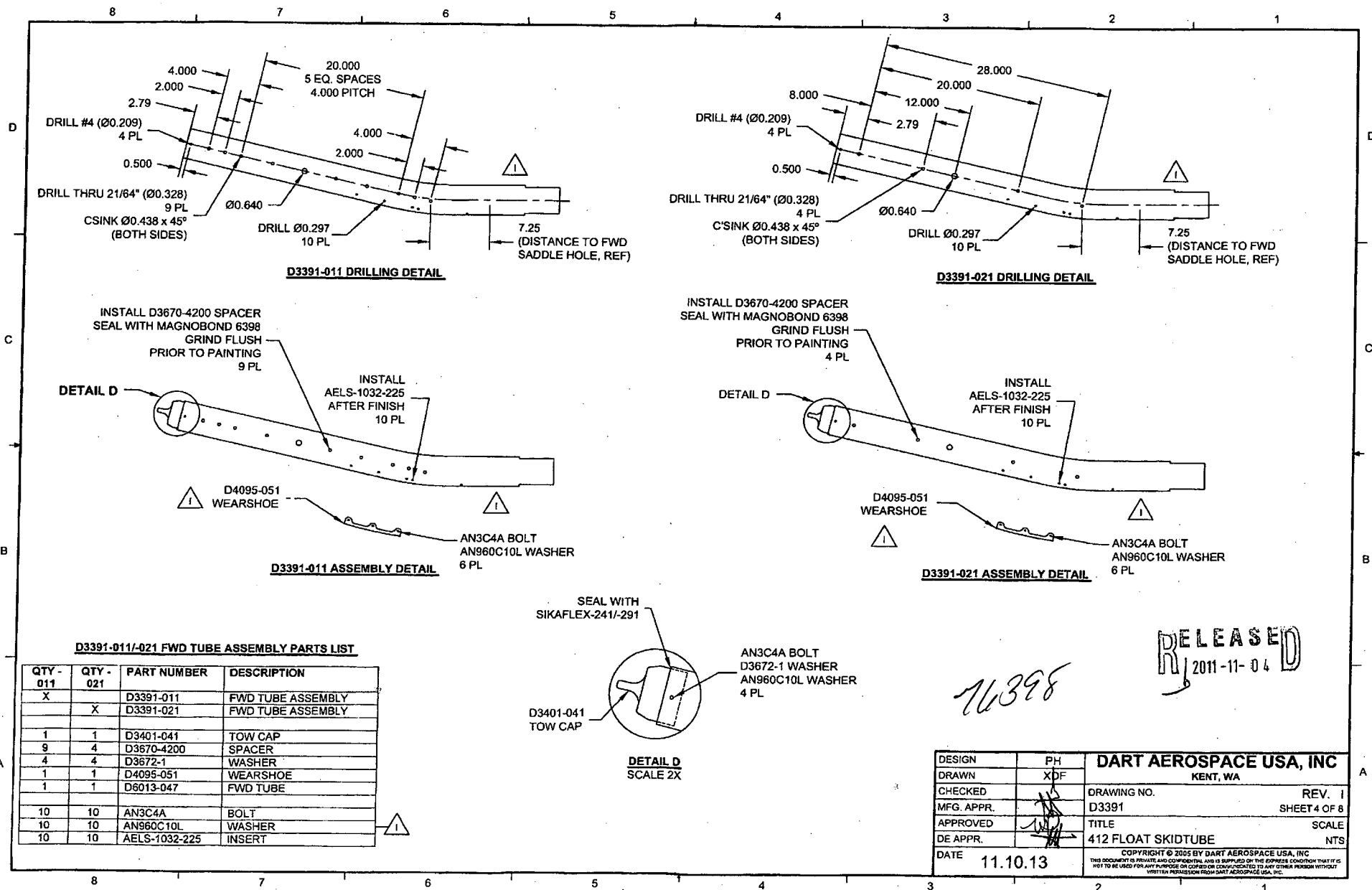
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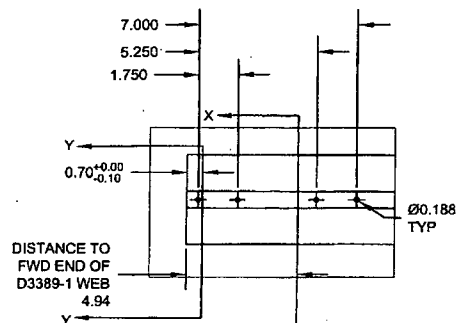
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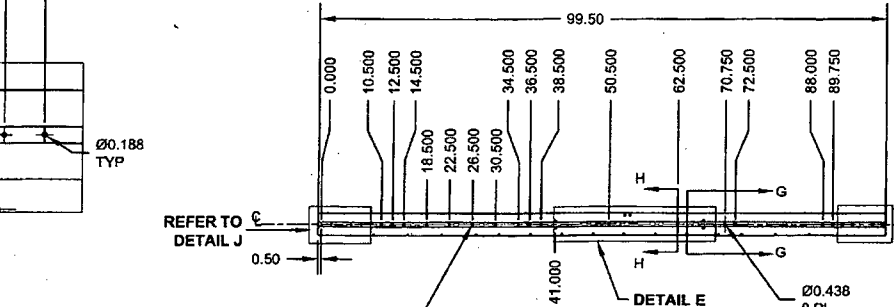
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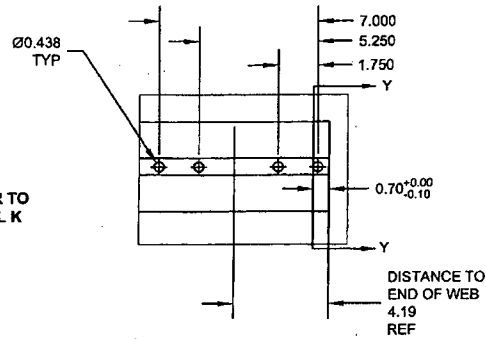
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DETAIL J
SCALE 4X



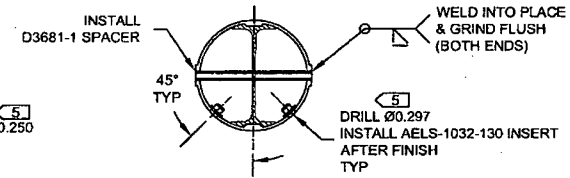
D3391-013 ASSEMBLY DETAIL



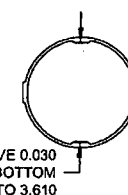
DETAIL K
SCALE 4X



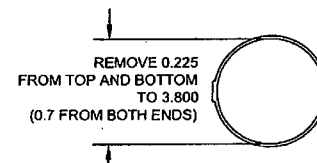
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



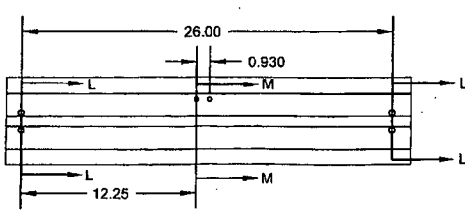
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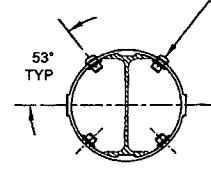
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

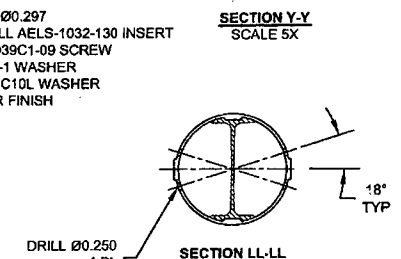
QTY	PART NUMBER	DESCRIPTION
1	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



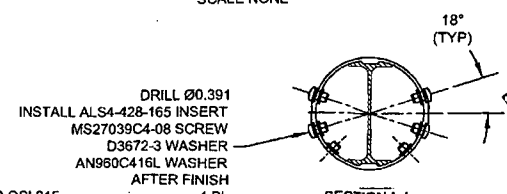
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

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2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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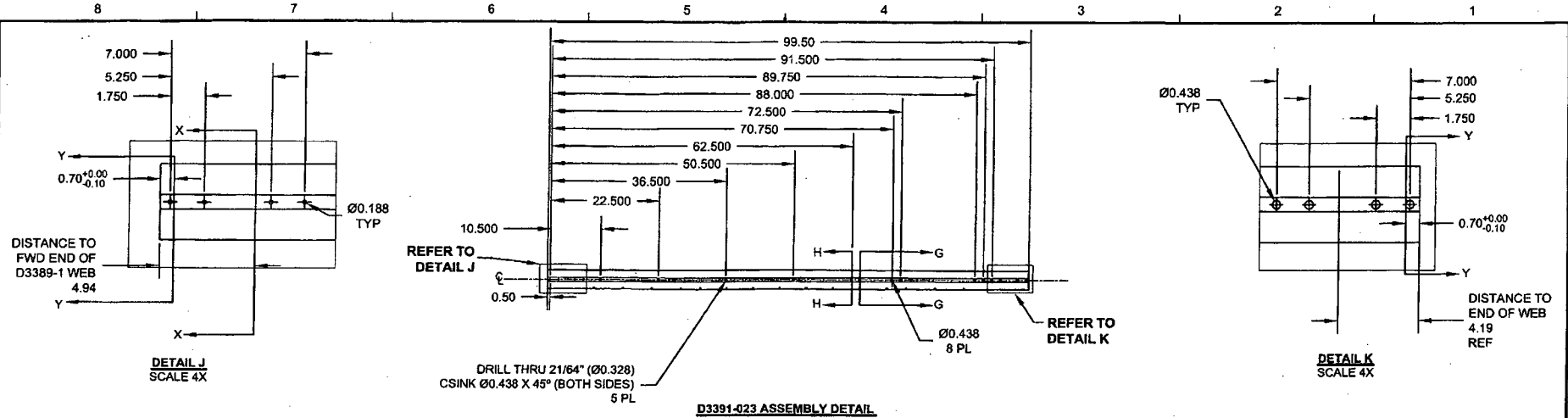
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

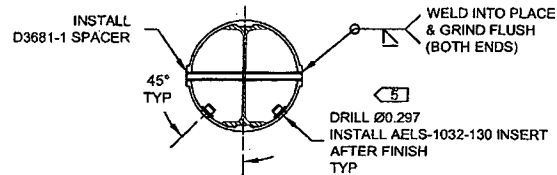
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

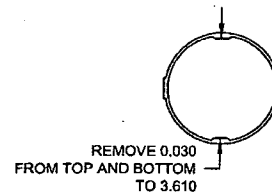
NOTE: Date & initial all entries



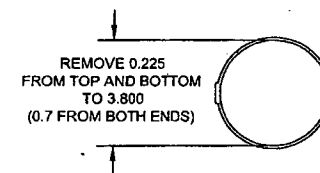
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
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MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
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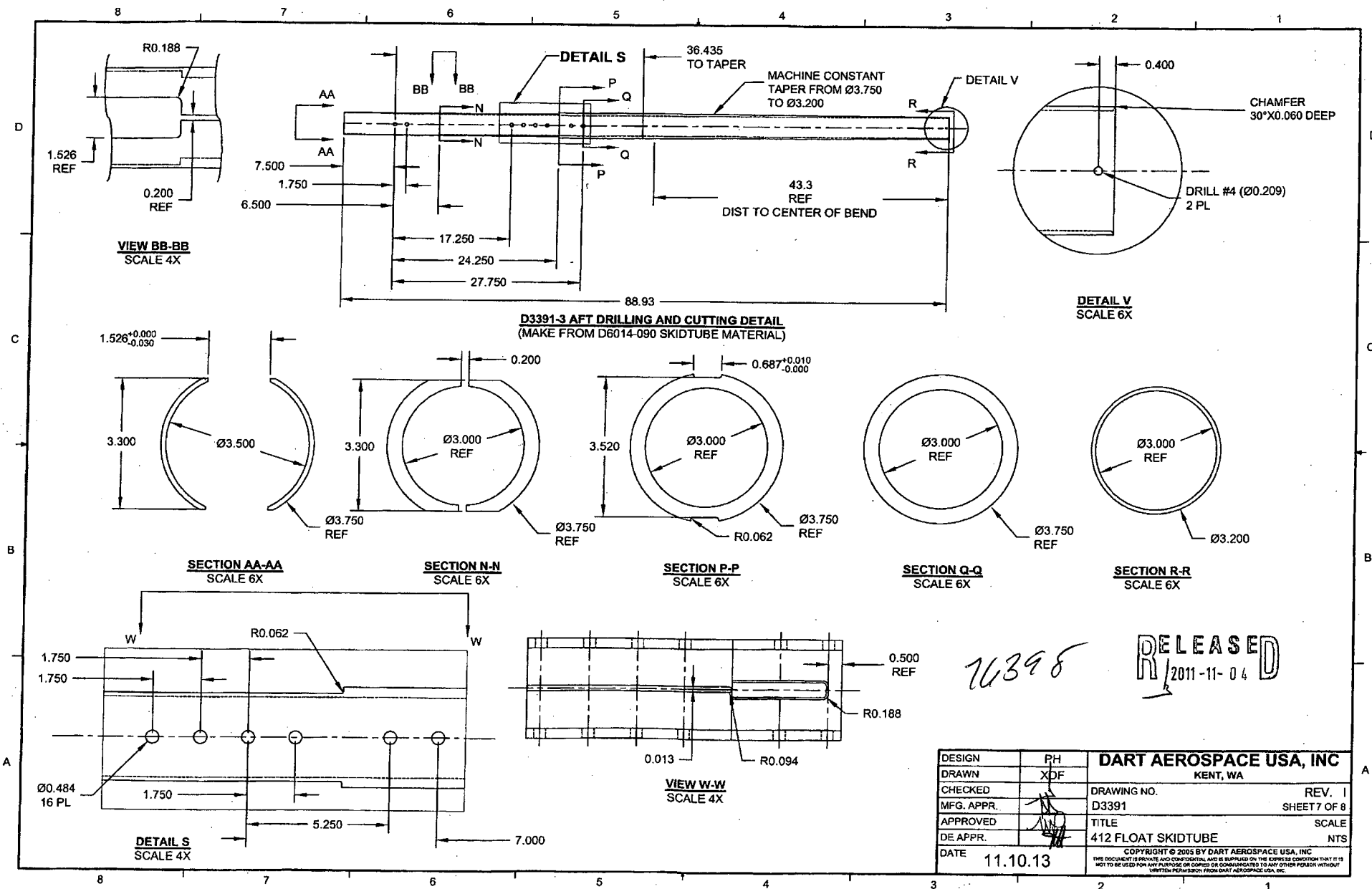
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



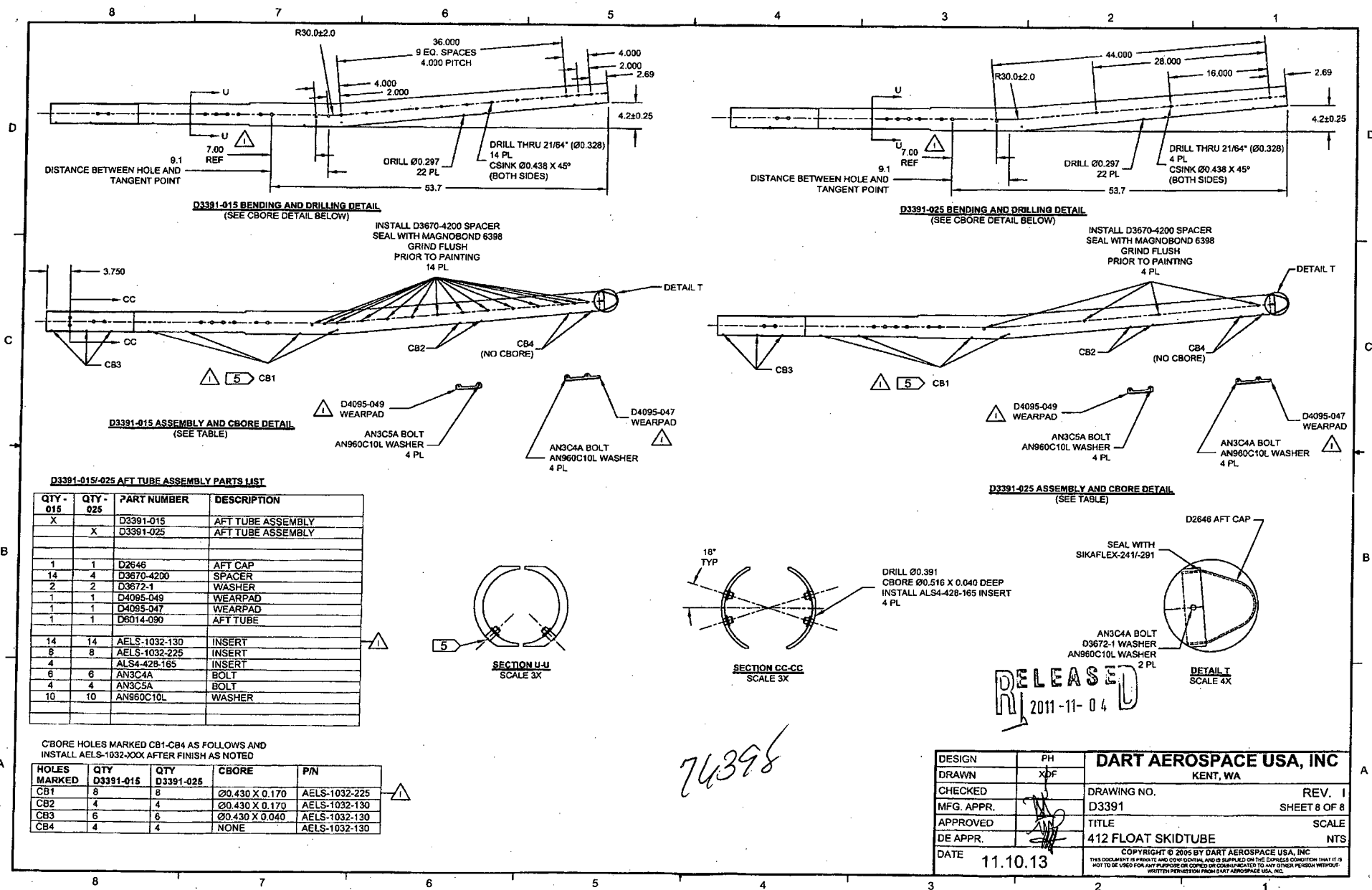
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C.	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries